

Work Order ID 51984

September 11, 2009 9:51:00 AM



Page 1

Item ID: D3822-5KGY

Accept



Setup Start



Revision ID: C

Item Name: Vertical Tunnel, Top-Grey

Stop



Start Date: 09/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/21/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: RL

Date: 09-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								

100

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

I-Cut Sheet to required Blank size

M111807
BB 09/15/09
~~BB~~ X1

110

0.00



Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA028 using tool DT9078
Dwg Rev: C
Folio Rev: B

BB 09/15/09
X6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51984

September 11, 2009 9:51:00 AM



Page 2

Item ID: D3822-5KGY

Accept



Setup Start



Revision ID: C

Stop



Item Name: Vertical Tunnel, Top-Grey

Start Date: 09/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/21/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control	Visually inspect part for proper formation and texture								
130	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									
140		0.00							
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	1-Trim to finished dimensions as per Dwg								

BB 09/16/09
X6W. 09/16/09
X6BB 09/16/09
X6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries
 H:\FORMS\Quality Assurance\approved QA\NCRWO RevE
 H:\FORMS\Quality Assurance\approved QA\NCRWO RevE

SHOP COPY

RETURN TO:
ENGINEERING
UNCONTROLLED
SUBJECT TO A
WITNESS
WORK CENTER
NO. 51

DART AEROSPACE LTD		Work Order: 51984
Description: Vertical Tunnel, Top		Part Number: D3822-5KIV/KGY
Inspection Dwg: D3822	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB

Date: 09/16/09

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.3	Min	.326	✓			
0.040	Min	.069	✓			
0.060	Min	.071	✓			

Measured by: BB

Date: 09/16/09

Audited by: Dh.

Date: 09/16/09

Prototype Approval:

N/A

Date:

N/A

Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue	KJ	

SHOP COPY

RETURN TO

ENGINEERING

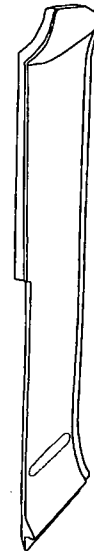
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SUBJECT TO AMENDMENT

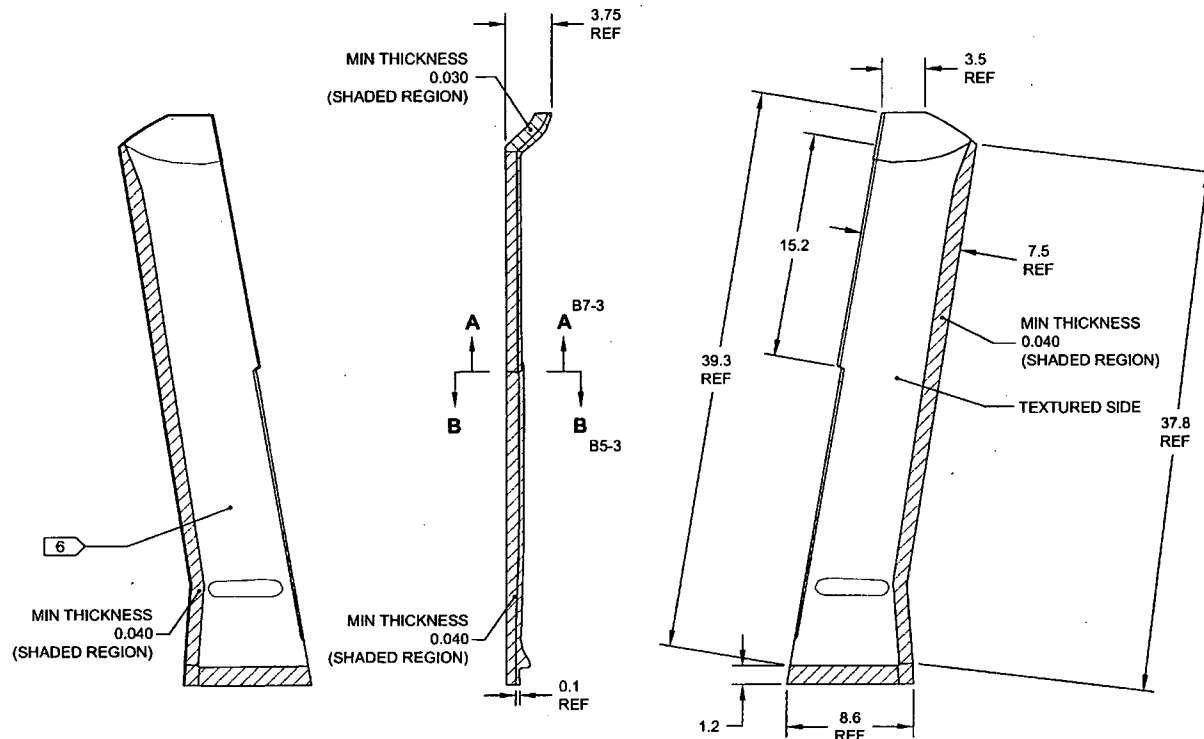
WITHOUT NOTICE

WORK ORDER

NO. 51984



RELEASED



D3822-1 VERTICAL TUNNEL, LH
(BELL 206 A/B)

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 1.1 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9073 PER DART QSI 022. TRIM PER MOLD.
- 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3822-1KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3822-1KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

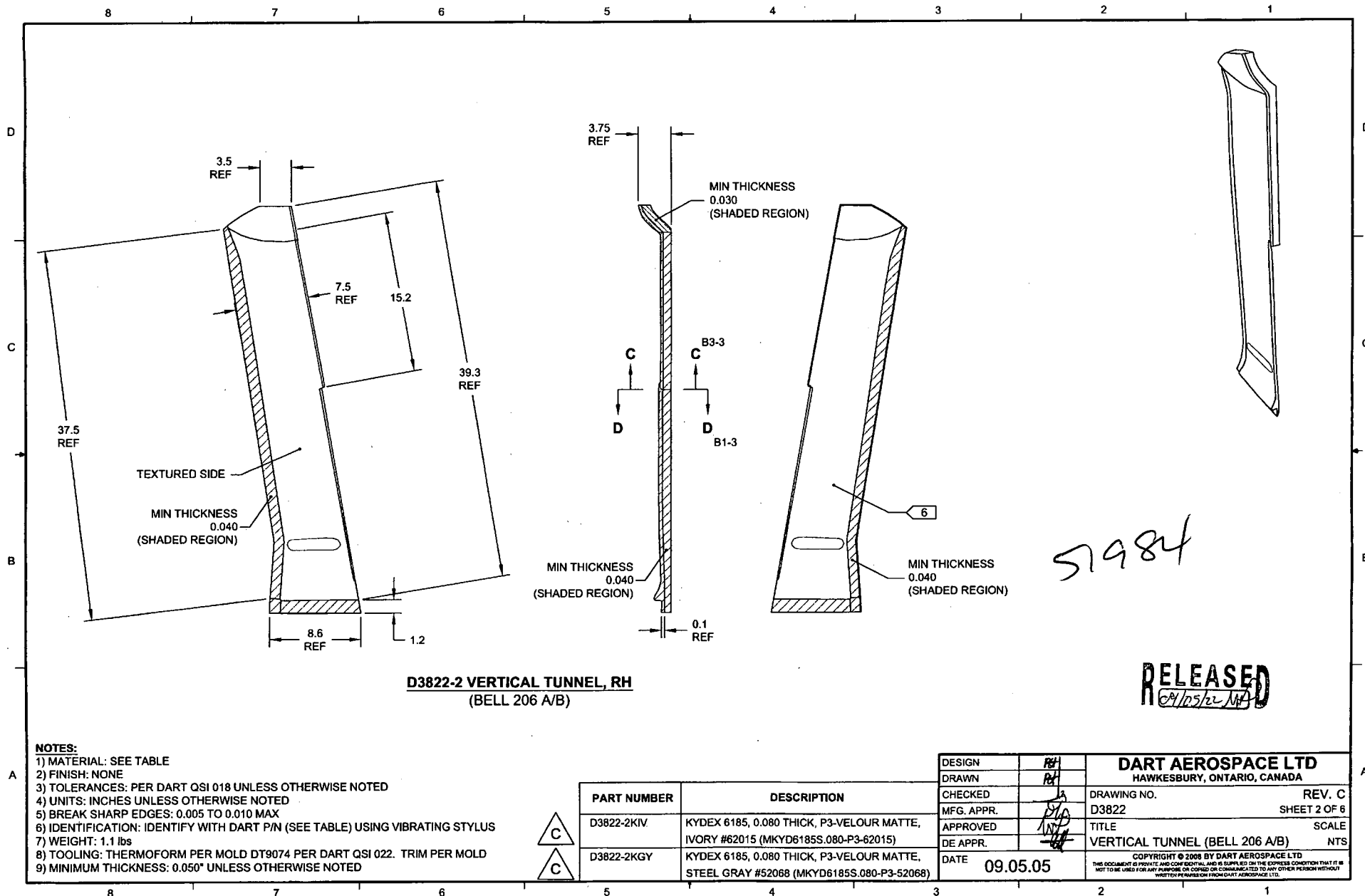
C	ADD STEEL GRAY COLOUR OPTION, ADD IVORY P/N'S D3822-1/-2/-3/-5/-7(KIV) AND ADD STEEL GRAY P/N'S D3822-1/-2/-3/-5/-7(KGY) (ZN A5-1, A5-2, A5-4, A5-5, A5-6)	PH	09.05.05
B	37.8 WAS 38.8 (ZN C8-4); MODIFY TOP OF -3 AND ADD VIEW J (ZN A3-4); INCREASE JOGGLE ON -3 (ZN C8-4); UPDATE VIEW F (ZN A1-4); REASON: TO IMPROVE FIT OF D206-781-151 KIT	PH	09.02.09
A	NEW ISSUE	PH	08.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	PH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.05.05		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3822 REV. C
SHEET 1 OF 6

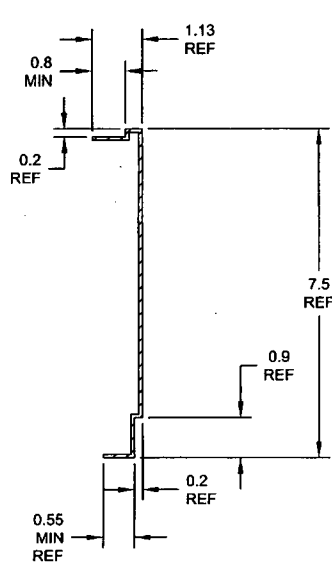
TITLE VERTICAL TUNNEL (BELL 206 A/B) SCALE NTS

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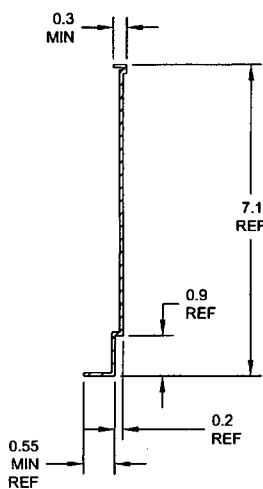


8 7 6 5 4 3 2 1

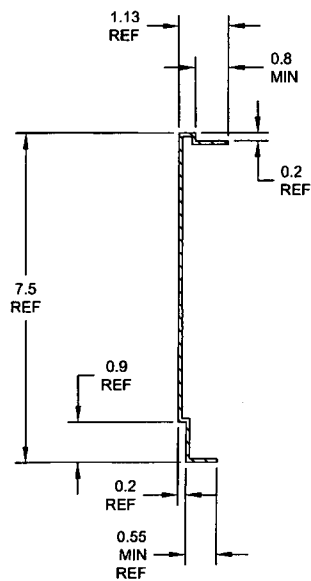
D
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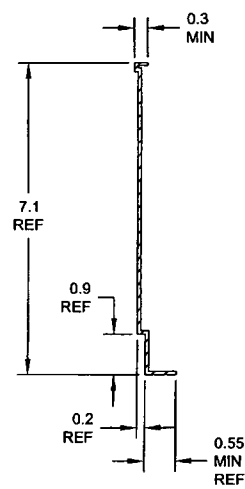
SECTION A-A C6-1



SECTION B-B C6-1



SECTION C-C C4-2



SECTION D-D C4-2

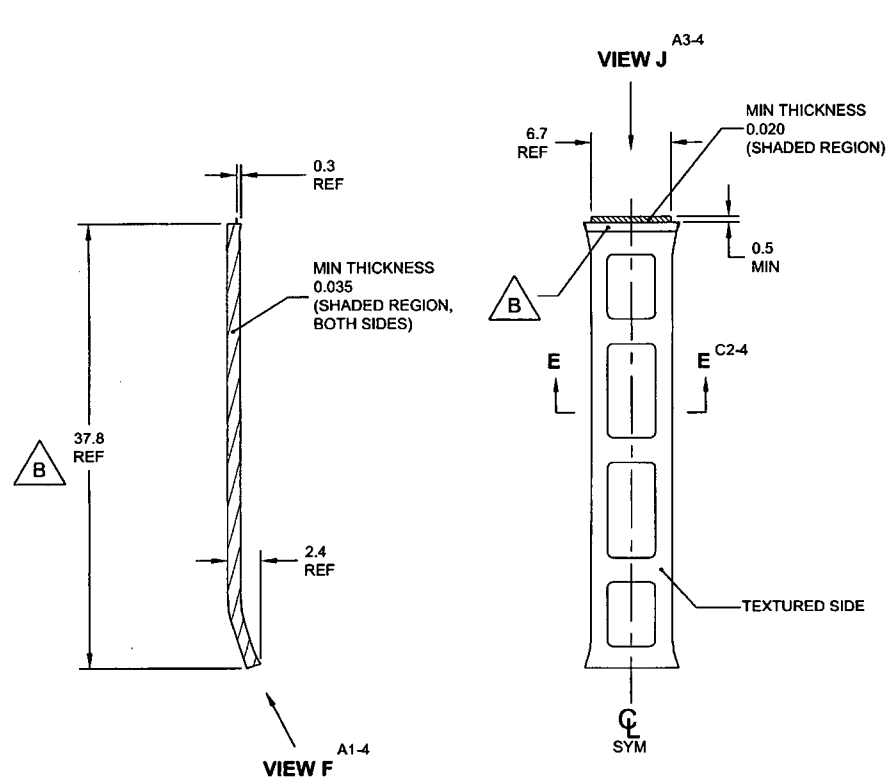
51984

RELEASED
09/05/2005

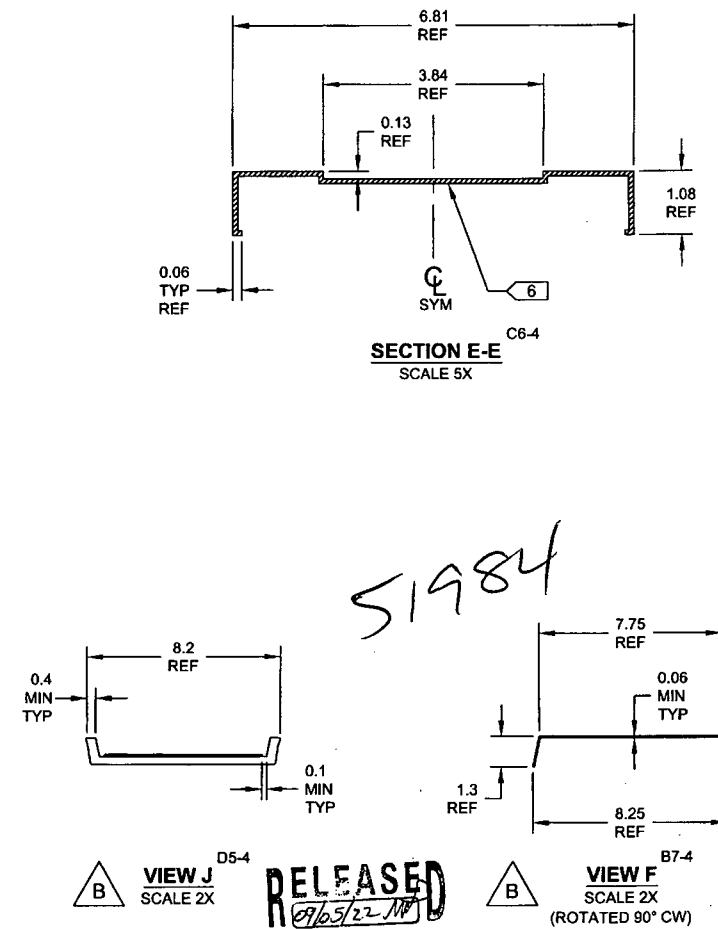
DESIGN	RA	DART AEROSPACE LTD	
DRAWN	RA	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RA	DRAWING NO. D3822	REV. C
MFG. APPR.	RA	SHEET 3 OF 6	
APPROVED	RA	SCALE	
DE APPR.	RA	VERTICAL TUNNEL (BELL 206 A/B) NTS	
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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1



D3822-3 VERTICAL TUNNEL, AFT CENTER
(BELL 206 A/B)

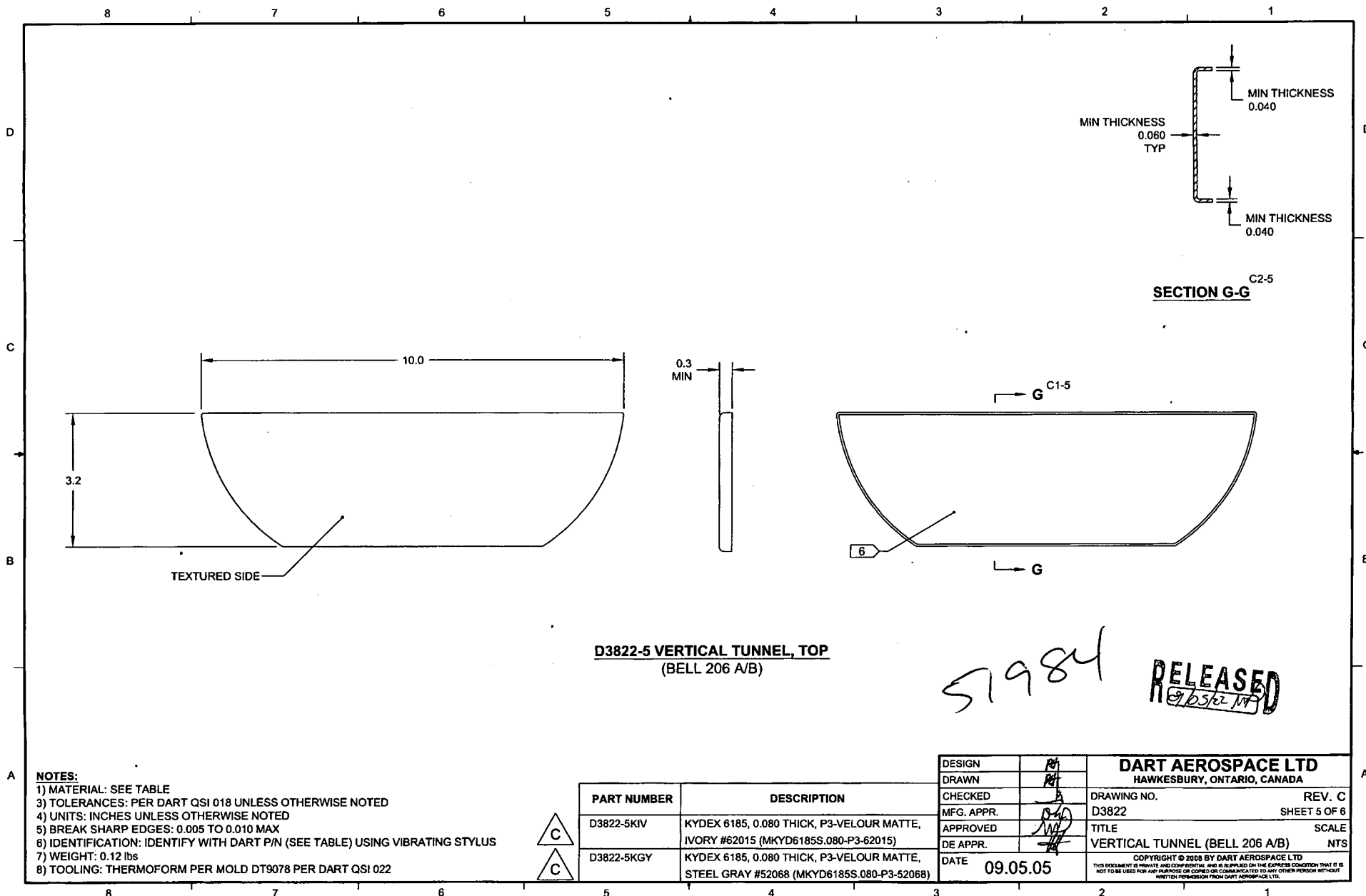


- NOTES:**
- 1) MATERIAL: SEE TABLE
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
 - 7) WEIGHT: 1.1 lbs
 - 8) TOOLING: THERMOFORM PER MOLD DT9072 PER DART QSI 022. TRIM PER MOLD
 - 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3822-3KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3822-3KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN	DART AEROSPACE LTD
DRAWN	HAWKESBURY, ONTARIO, CANADA
CHECKED	DRAWING NO. REV. C
MFG. APPR.	D3822 SHEET 4 OF 6
APPROVED	TITLE SCALE
DE APPR.	VERTICAL TUNNEL (BELL 206 A/B) NTS
DATE	09.05.05

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MIN THICKNESS
0.040MIN THICKNESS
0.0400.20
0.15

2.0

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REF0.3
REF

5.9

H

17.00
MIN

TEXTURED SIDE

H^{B1-6}

SECTION H-H B3-6

D3822-7 VERTICAL TUNNEL, LOWER
(BELL 206 A/B)

51984

RELEASED
09/05/22-MP**NOTES:**

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) WITH VIBRATING STYLUS
- 7) WEIGHT: 0.36 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9396 PER DART QSI 022
- 9) MINIMUM THICKNESS: 0.060" UNLESS OTHERWISE NOTED

C

C

PART NUMBER	DESCRIPTION
D3822-7KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3822-7KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN	PA	DART AEROSPACE LTD	
DRAWN	PA	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PA	DRAWING NO.	REV. C
MFG. APPR.	PA	D3822	SHEET 6 OF 6
APPROVED	PA	TITLE	SCALE
DE APPR.	PA	VERTICAL TUNNEL (BELL 206 A/B)	NTS
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